



M-90 E312-16

FEATURES

- *GOOD CRACK RESISTANCE
- *GOOD MECHANICAL PROPERTIES
- * EASY TO REMOVE SLAG

APPLICATION

- *Buffer layer for build up
- *welding dissimilar steels

CLASSIFICATION

*A5.4/ ASME SFA5.4 E312.16

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.10	0.45	1.4	0.018	0.013	28.5	9.6	

MECHANICAL PROPERTIES

T.S	EL
N/mm2 (lbs/in 2)	(%)
803 (116,600)	22.0

WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2
LENGTH (mm)	300	350
CURRENT (amps)	45-80	65-110

CURRENT

*AC or DC +/-

WELDING POSITIONS

